

Work Order ID 155044

Friday, January 06, 2017 7:13:49 AM

155044

Page 1

Item ID: D2731-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Mounting Lug
Start Date: 1/6/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 1/18/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: DAS 13 9-89 Date: JAN 06 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2731	Rev C								
110	Outsource process - Machining HAAS CNC VERTICAL MACHINING #1	0.00							DAS 13 9-89
110									
Outsource5	Memo	719.97							
Outsource process - Machining	Issue P/O to Metec : <u>34837</u> Machine as per dwg C of C is required								
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.08							
Packaging	ENSURE C OF C IS ATTACH.								
130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							DAS 38 9-89
Quality Control									

MAR 07 2017

Work Order ID 155044

Friday, January 06, 2017 7:13:49 AM

155044

Page 2

Item ID: D2731-7 Accept ***N900040100*** Setup Start ***NS1***
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Item Name: Mounting Lug
Start Date: 1/6/2017 Start Qty: 24.00 ***24*** Cust Item ID:
Required Date: 1/18/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.04							
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: _____ FINISH TIME: _____ OVEN TEMPERATURE: _____	0.00 0.04							
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.04				24			DAS 38 9-89 MAR 07 2017

Work Order ID 155044

Friday, January 06, 2017 7:13:49 AM

155044

Page 3

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Required Date: 1/18/2017 Req'd Qty: 24.00 ***24*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: SS2A	0.00							
170									
Packaging	Memo	0.04				24			
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.40							
Quality Control									

MAR 05 2017
DAS
6
9-89

17/3/8

MAR 08 2017

Picklist Print

Friday, January 06, 2017 7:13:49 AM

Page 1

Work Order ID: 155044

155044

Parent Item: D2731-7

D2731-7

Parent Item Name: Mounting Lug

Start Date: 1/6/2017

Required Date: 1/18/2017

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP D00.05.19 Added inspect level 8, removed P/O powder
coating EC IPP REV: E 13.06.25
OUTSOURCE METEC DD VERF: JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2423		Manufactured	No			110	f	422.4855	0.0683	1.725474			
D2423									**			JAN 06 2017	DAS 13 9-89
Lug Extrusion													

Location

Loc Qty

Loc Code

Metec

422.4855307

127892

36.5122647

131451

97.654451

148835

288.318815

D2731-7P

Purchased

No

100

Each

0.0000

1

24

D2731-7P

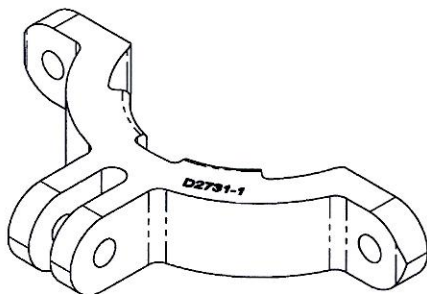
Lug

24x SP17026

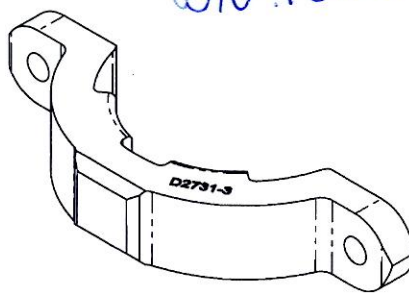
JAN 06 2017

DAS
13
9-89

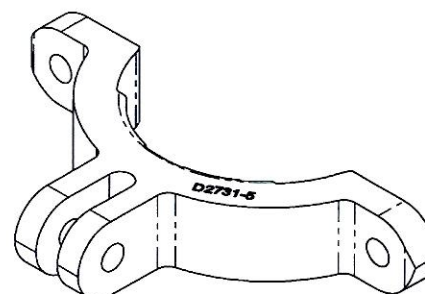
W10155044



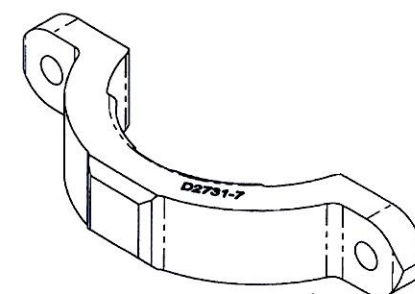
D2731-1 MOUNTING LUG



D2731-3 MOUNTING LUG



D2731-5 MOUNTING LUG



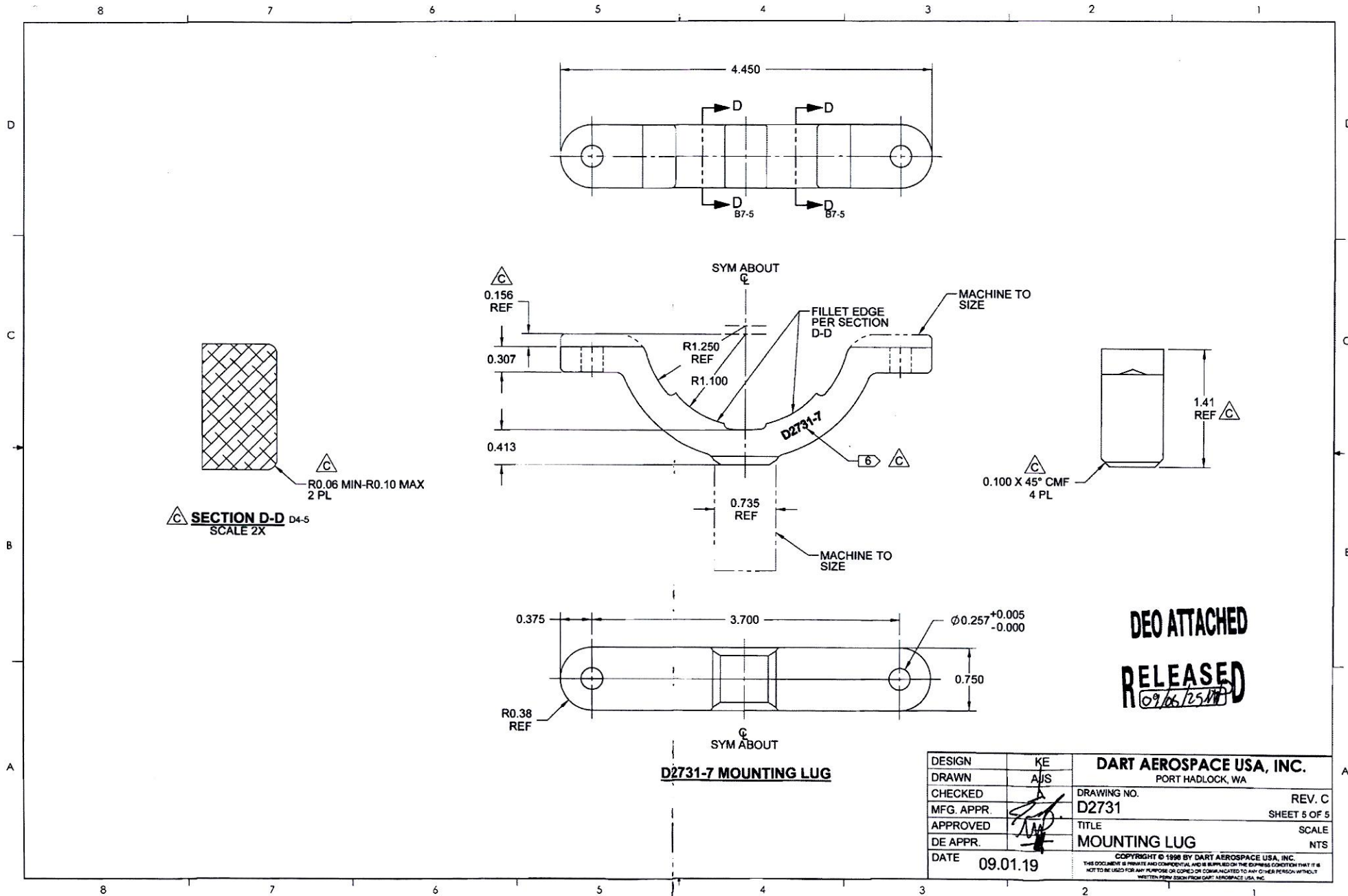
D2731-7 MOUNTING LUG

**DEO ATTACHED
RELEASED**
CP/62/25/14

NOTES:

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.17 lbs
-3: 0.15 lbs
-5: 0.16 lbs
-7: 0.14 lbs

C	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A, B-B, C-C & D-D FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.19
B	REVISED DIMENSIONS	KE	99.07.06
A	NEW ISSUE	KE	98.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D2731 TITLE MOUNTING LUG SCALE NTS	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



D2731-7 MOUNTING LUG

DESIGN	KE	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2731	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.19	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

DEO ATTACHED
RELEASED
09/06/25/19



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 21567
Date: Feb 02, 2017
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 34837	Sold By: VanDenYssel, David
Shipped By: your truck	Ship Date: Feb 02, 2017

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, as per drawing D2230 Rev. G Alodine and Paint as per QSI 005	Each	50	50	
D2230-3 Mounting Lug, as per drawing DD230 Rev. G Alodine and Paint as per QSI 005	Each	80		
D4091-1 Lug, as per drawing D4091 Rev.A Alodine and Paint as per QSI 005	Each	20		
D2731-7 LUG, as per drawing D2731 Rev. C Alodine and Paint as per QSI 005	Each	24	24	
DAS 38 9-89				
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				

Received by

SPI7026.

Thank you for your order!



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0
Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
50	D2230-1	Lug Paint Batch # 20851	Material B148835 34837
24 ✓	D2731-7	Lug Paint Batch # 20851	Material B148835 34837

Material supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Jan Norris

Vankleek Hill, February 02, 2017



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO34837**

Purchase Order Date 1/5/2017

PO Print Date 1/6/2017

Page Number 2 of 3

Order From :

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

VC-MET003

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via: Dart Truck

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

3 D4091-1P

Lug

1/18/2017

Yes

1/18/2017

20.00

Each

\$16.10

\$322.00

AS PER DWG D4091 REV. A
B154947

ALODINE AND PAINT AS PER QSI 005

5 D2731-7P

Lug

1/18/2017

Yes

1/18/2017

24.00

Each

\$15.00

\$360.00

AS PER DWG D2731 REV. C
B155044

ALODINE AND PAINT AS PER QSI 005

Line Total:

\$322.00

Line Total:

\$360.00

Note:

1/6/2017